

Ship Aug 21

Work Order ID 135702

135702

Page 1

Monday, August 17, 2015 8:03:12 AM

Item ID: DSI 9356-011 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Basket Repair

Start Date: 8/17/15 Start Qty: 2.00 *2*

Required Date: 8/21/15 Req'd Qty: 2.00 *2*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: H Date: 15-8-17 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
DSI9356	B								
100	Document Control	0.00	DAS 27 9-89	DAS 26 9-89					
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP DSI 9356-011 CHG001								

MW 15-8-17 (2)

2x 15-08-20

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

AUG 17 2015

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

2x 8-15-08-20

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 135702

Monday, August 17, 2015 8:03:12 AM

135702

Page 2

Item ID: DSI 9356-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Repair
Start Date: 8/17/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/21/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9356-011								
	Location: <u>123</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

2 DAS 6 9-89
AUG 20 2015
MCJ
20150820

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, August 17, 2015 8:03:22 AM

Page 1

Work Order ID: 135702

135702

Parent Item: DSI 9356-011

DSI 9356-011

Parent Item Name: Basket Repair

Start Date: 8/17/15

Required Date: 8/21/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.29 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A		Purchased	No			110	Each	207.0000	4	8			
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AN4-15A

Bolt

DAS
26
9-89

Location	Loc Qty	Loc Code
GA	40	
120449	40	
ST325A	3	
m132317	3	
ST343	164	
m132551	164	

DAS
27
9-89

BLRS-020		Purchased	No			110	Each	14.0000	4	8			
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BLRS-020

Quick Release Pin (1/4" x 1.5")

DAS
26
9-89

Location	Loc Qty	Loc Code
FG	4	
122168	4	
ST550	9	
m132935	9	
ST551	1	
m131692	1	

1329952

DAS
27
9-89

D3907-1		Manufactured	No			110	Each	57.0000	8	16			
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D3907-1

Bushing

DAS
26
9-89

Location	Loc Qty	Loc Code
WA004	57	
112653	8	
112659	1	
128586	48	

DAS
27
AUG 17 2015

DQA: _____ Date: _____



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Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
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								Lead hand / Supervisor Approval Verification	
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF, CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.I.R.M.S.1405

IN CASES WHERE THE MOUNTING HOLES AT THE BASE OF THE D350-607-041/-043/-045/-047 BASKET ARE ELONGATED DUE TO WEAR OR DAMAGE, IT IS ACCEPTABLE TO REPAIR THE HOLES WITH THE FOLLOWING REPAIR PROCEDURE:

REPAIR PROCEDURE:

- 1) ENLARGE THE INSTALLATION HOLES ON THE D2325 GUSSETS PER FIGURE 1 AND DEBURR SHARP EDGES.
- 2) INSTALL THE D3907-1 BUSHING BY T.I.G WELDING PER MIL-STD-2219/AMS-STD-2219 CLASS "C" USING ER308L FILLER ROD AS SHOWN IN DETAIL B.
- 3) TOUCH UP PAINT IN ACCORDANCE WITH ICA-D350-607.
- 4) RE-INSTALL THE BASKET IN ACCORDANCE WITH ICA-D350-607 SUBSTITUTING THE INSTALLATION HARDWARE PER TABLE 1.

TABLE 1

BOLT			QUICK RELEASE PIN		
EXISTING	REPLACEMENT	QTY	EXISTING	REPLACEMENT	QTY
AN4-12A	AN4-15A	4	BLRS-010	BLRS-020	4

PARTS LIST

ITEM	QTY -011	PART NUMBER	DESCRIPTION
	X	DSI 9356-011	BASKET REPAIR KIT
1	8	D3907-1	BUSHING
7	4	AN4-15A	BOLT
8	4	BLRS-020	QUICK RELEASE PIN

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.03.11
CERT. NO.: SH94-14
ISSUE NO.: 4

B	DSI UPDATED TO MAKE DSI INTO KIT AS WELL AS REPAIR INSTRUCTIONS. TITLE UPDATED. SEE NCR 09-036 FOR DETAILS.	AJS	09.03.11
A	NEW ISSUE	MB	06.09.28
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9356	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ELONGATED HOLE REPAIR KIT	NTS
DATE	09.03.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

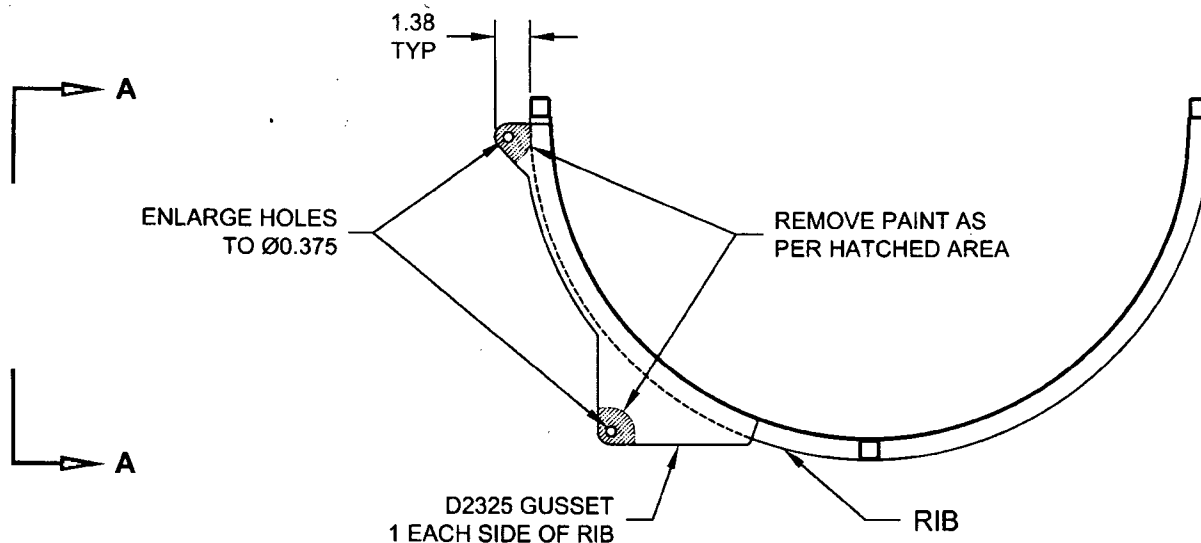
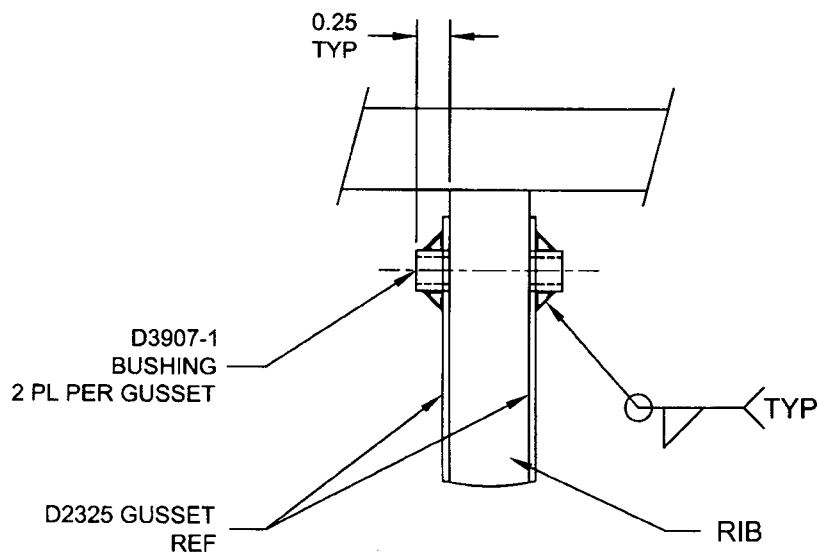
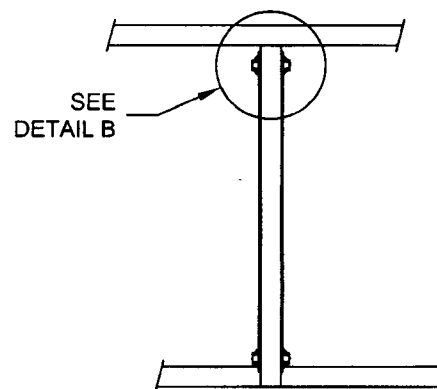


FIGURE 1: WELDING PREPARATION



DETAIL B



**VIEW A-A: BUSHING
INSTALLATION**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.03.11
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ADS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9356	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ELONGATED HOLE REPAIR KIT	NTS
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REF DAS 26 15-08-20

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF, CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.I.R.M.S.1405

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ITEM	QTY -011	PART NUMBER	DESCRIPTION
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7	4	AN4-15A	BOLT
8	4	BLRS-020	QUICK RELEASE PIN

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: <u>D. SHEPHERD (DE # 02)</u>
DATE: <u>09.03.11</u>
CERT. NO.: <u>SH94-14</u>
ISSUE NO.: <u>4</u>

B	DSI UPDATED TO MAKE DSI INTO KIT AS WELL AS REPAIR INSTRUCTIONS. TITLE UPDATED. SEE NCR 09-036 FOR DETAILS.	AJS	09.03.11
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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9356	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ELONGATED HOLE REPAIR KIT	NTS
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